



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

12655

D4703-041

Job Sheet 189324



008396

Part No: D4703-041

Job Qty: 4 pcs

Part Name: Lock Pin Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/22/19

Job Tracking No:

Due Date: 2/6/19

Created By: Dara Macdonald

Type: SOLD

Description:

Note: DWG REV B SHEETS 1-2,4 IPP REV:A 12.09.10 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	4 pcs		2/6/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

DAS

58 MAR 01 2019
9-89

					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	DAS
					Small Fab - 1 - B4B	58
					Small Fab - 2 - B4B	9-89
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
120	Small Fab - 2 - B4B	4 pcs	2/6/19	0.00 0.48	Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
130	QC 5	4 pcs	2/6/19	0.00 0.00	QC 5 - 3	
					QC 5 - 38	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	DAS
					QC 5 - 9	68
					QC 5 - 50	9-89
140	Packaging 3-1 - Stock - B4B	4 pcs	2/6/19	0.00 0.00	QC 5 - 30	
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	

					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
150	QC 21 - SA	4 pcs	2/6/19	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	

Part Op 110 - (Pick Kit)
 Descriptions: 120 - (Small Fab)
 130 - (QC5- Inspect part completeness to step on W/O)
 140 - Packaging3 (Identify as per dwg & Stock Location: _____)
 150 - (QC21- Final Inspection - Work Order Release)

MAR 01 2019 21 9-86

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4703-043	Lock Pin Base	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	S150344
D4705-1	Pin, Quick Release	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	716326

Job Allocations

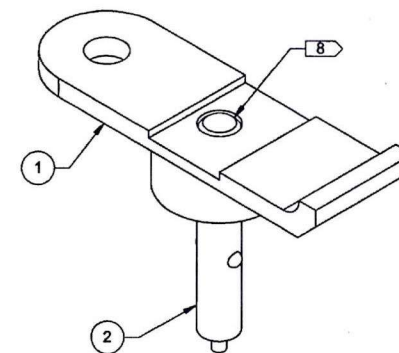
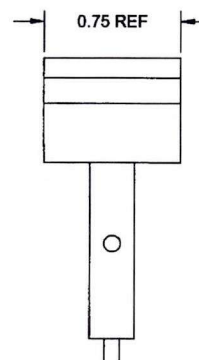
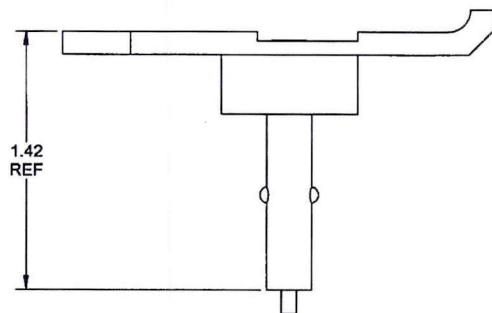
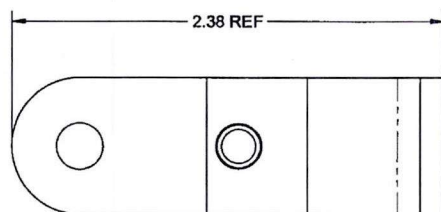
Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	D4703-043	4	0	0
	D4705-1	4	58	0

Part Specifications

Specifications could not be found.

ST110
ST110

ITEM	QTY	P/N	DESCRIPTION
	X	D4703-041	LOCK PIN ASSY
1	1	D4703-043	LOCK PIN BASE
2	1	D4705-1	QUICK RELEASE PIN



D4703-041 LOCK PIN ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: 0.05 lbs
- 8) APPLY LOCTITE 262 TO D4703-043 THREADS PRIOR TO FASTENING D4705-1

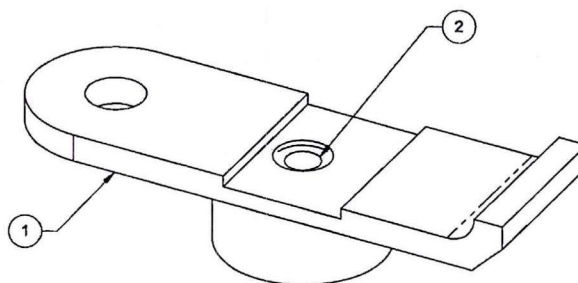
RELEASED

2017 MAY 24
EN 17-571

B	ADDED D4703-045 AND D4703-3	VS	17.01.03
A	NEW ISSUE	RP	12.09.19
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	VS		
CHECKED	WK	DRAWING NO.	REV. B
MFG. APPR.	JLM	D4703	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LOCK PIN ASSY	NTS
DATE	17.01.03	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

APPROVED

ITEM	QTY. -043	P/N	DESCRIPTION
	X	D4703-043	LOCK PIN BASE
1	1	D4703-1	LOCK PIN BASE
2	1	MS21209F4-15	HELICOIL, LOCKING



D4703-043 LOCK PIN BASE

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

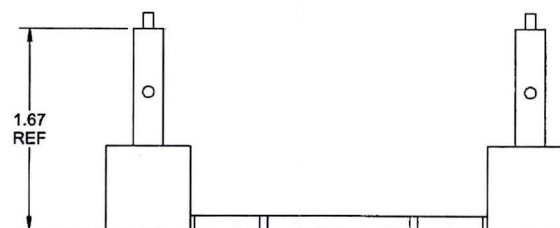
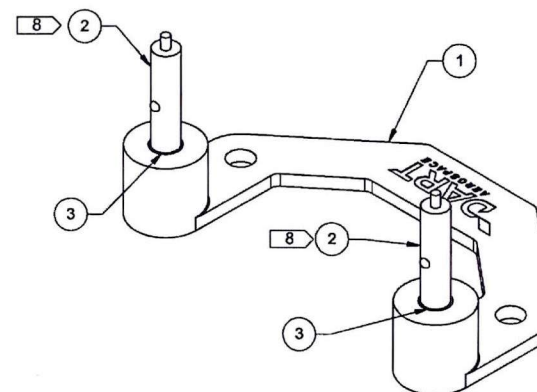
RELEASED

2017 MAY 24 *qr*

APPROVED

DESIGN	VS	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	VS		
CHECKED	WK	DRAWING NO.	REV. B
MFG. APPR.	JLM	D4703	SHEET 2 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LOCK PIN ASSY	NTS
DATE	17.01.03	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

ITEM	QTY	P/N	DESCRIPTION
	X	D4703-045	LOCK PIN ASSY
1	1	D4703-3	LOCK PIN BASE
2	2	D4705-1	QUICK RELEASE PIN
3	2	MS21209F4-15	HELICOIL, LOCKING



D4703-045 LOCK PIN ASSY

NOTES:

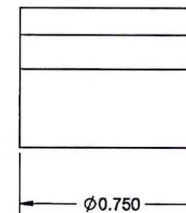
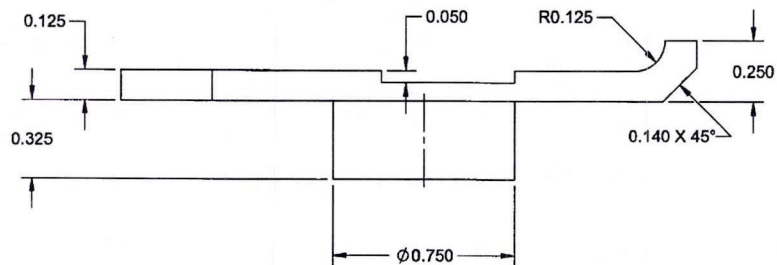
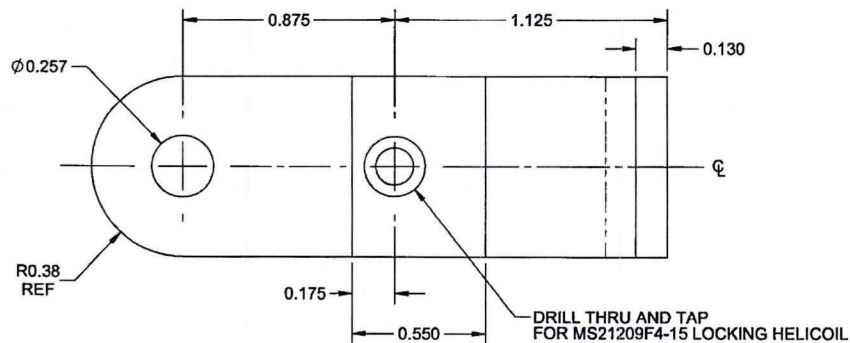
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: 0.12 lbs
- 8) APPY LOCTITE 262 TO MS21209F4-15 THREADS PRIOR TO FASTENING D4705-1

RELEASED

2017 MAY 24 *up*

APPROVED

DESIGN	VS	DART AEROSPACE USA, INC.	
DRAWN	VS	EUGENE, OR	
CHECKED	WK	DRAWING NO.	REV. B
MFG. APPR.	JLM	D4703	SHEET 3 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LOCK PIN ASSY	NTS
DATE	17.01.03	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D4703-1 LOCK PIN BASE

NOTES:

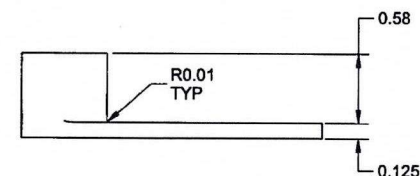
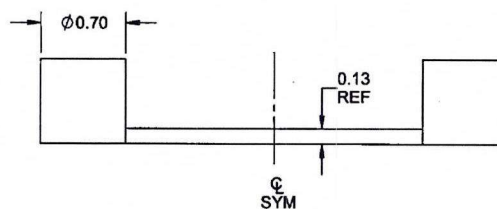
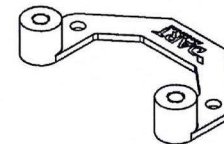
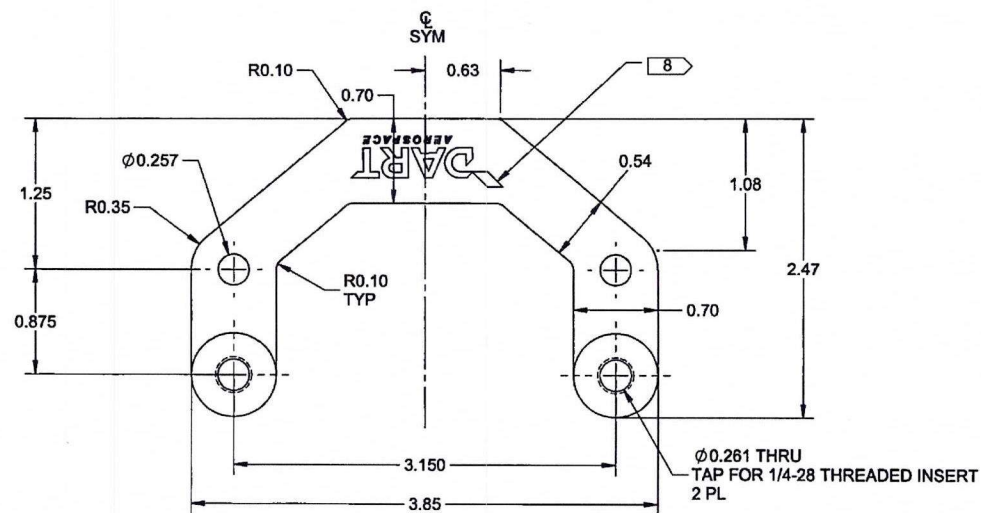
- 1) MATERIAL: 6061-T6/T651 PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221
REF. DART SPEC. M6061T6B
- 2) FINISH: BLACK ANODIZE PER MIL-8625F, TYPE III, CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

RELEASED

2017 MAY 24

APPROVED

DESIGN	VS	DART AEROSPACE USA, INC.	
DRAWN	VS	EUGENE, OR	
CHECKED	WK	DRAWING NO.	REV. B
MFG. APPR.	JLM	D4703	SHEET 4 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LOCK PIN ASSY	NTS
DATE	17.01.03	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC.	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			



D4703-3 LOCK PIN BASE

NOTES:

- 1) MATERIAL: 6061-T6/T651 PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221 REF. DART SPEC. M6061T6B
- 2) FINISH: BLACK ANODIZE PER MIL-8625F, TYPE III, CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs
- 8) ENGRAVE "DART" LOGO AS SHOWN 0.003 - 0.005 DP

RELEASED

2017 MAY 24 *qp*

APPROVED

DESIGN	VS	DART AEROSPACE USA, INC.	
DRAWN	VS	EUGENE, OR	
CHECKED	WK	DRAWING NO.	REV. B
MFG. APPR.	JLM	D4703	SHEET 5 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LOCK PIN ASSY	NTS
DATE	17.01.03	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



DART AEROSPACE
1270 Aberdeen Street
Hawkesbury, ON K6A 1
CANADA
TEL.: 1 613 632-52
Email: sales@dartaer.com
www.dartaerosp.ca

Container No: S157981



Part: D4703-041

Job No: 189324

Serial No/Batch: S157981

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/01/19